

Date: Monday, 18/08/2008 3:45:18 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	UPPER BLADE SUPPORT AND COVER ASSEMBLY
<b>Job Number</b> :	41370		
<b>Estimate Number</b> :	13520		
<b>P.O. Number</b> :		<b>Part Number</b> :	PB674300121
<b>This Issue</b> :	18/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	B6743001 P.10
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41292	<b>Drawing Revision</b> :	B1
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08.8.18</u>	<b>Due Date</b> :	18/09/2008
<b>Comment</b> :	Est Rev:A 08-07-25 new issue DD verified by:ec		

Qty: 8 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PB674300175	Upper Blade Support Ass'y
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 Upper Blade Support Ass'y  
 batch: 41514

mf 08-10-21

2.0	PB6743001173	Cover Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 Cover Plate  
 batch: B40050 ~~not~~ B41481

mf 08-10-21

3.0	PB674300185	PB67-43001-85
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 PB67-43001-85  
 batch: B40097 x 4, B 41517 x 4

mf mf 08-10-21

4.0	MS27039110	Screw
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**Comment:** Qty.: 10.0000 Each(s)/Unit Total : 160.0000 Each(s)  
 Screw  
 batch: M18x36x40, M108986x40

mf 08-10-21

5.0	NAS1149F0316P	WASHER
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**Comment:** Qty.: 10.0000 Each(s)/Unit Total : 160.0000 Each(s)  
 WASHER  
 batch: M108473x13mx, M10903x77

mf 08-10-21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 3:45:18 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER BLADE SUPPORT AND COVER ASSEMBLY

Job Number: 41370

Part Number: PB674300121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(8)

Comment: Assemble as per dwg PB67-43001

*M-L / FL*

*08/10/21*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/10/22 (K8)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *510*

*01/10/20*

*(QX) SP*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/10/22*

Job Completion



*MF 08-10-22*

**Dart Aerospace Ltd**

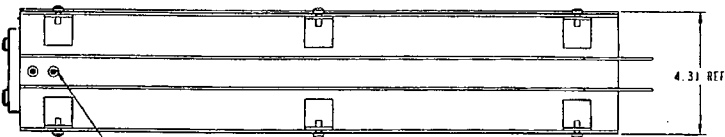
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

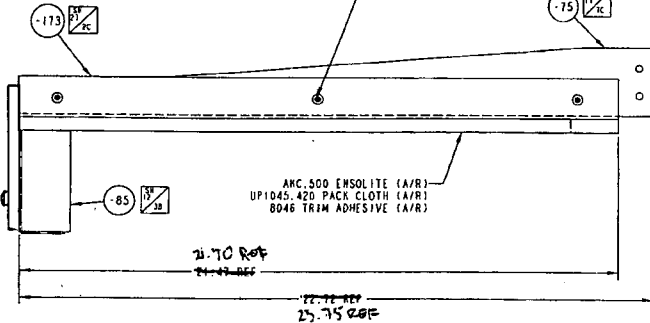
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Ø.250 THRU -173  
MATCH DRILL WITH HOLE  
PATTERN OF -75  
MS27039-1-10 SCREW  
NAS1149F0316P WASHER  
2 PLACES

MATCH DRILL COVER TO HOLES IN  
ANGLE BRACKETS. ATTACH USING  
MS27039-1-10 SCREW  
NAS1149F0316P WASHER  
6 PL (3 PL OPP)

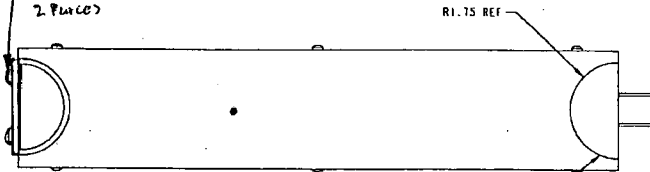


AKC.500 ENSOLITE (A/R)  
UP1045.420 PACK CLOTH (A/R)  
8046 TRIM ADHESIVE (A/R)

21.70 REF

25.75 REF

MS27039-1-10 SCREW  
NAS1149F0316P WASHER  
2 PLACES

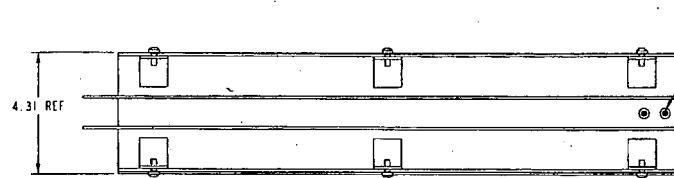


R1.75 REF

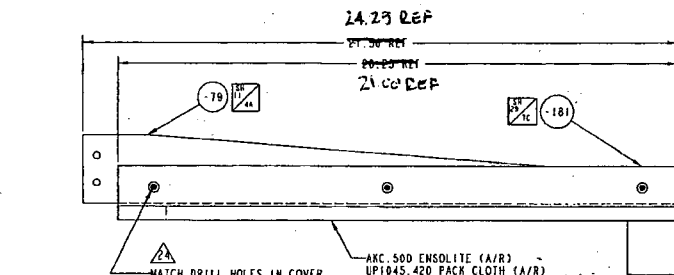
CUTOUT ENSOLITE FOR INTERFACING WITH -11 & -13 ASSEMBLIES

② -21 UPPER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500



Ø.250 THRU -181  
MATCH DRILL -181 WITH  
EXISTING HOLE PATTERN  
OF -79  
MS27039-1-10 SCREW  
NAS1149F0316P WASHER  
2 PLACES



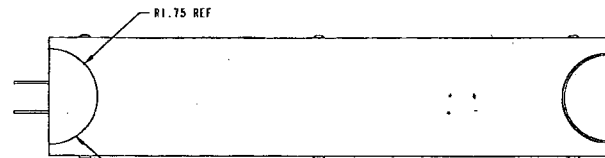
24.23 REF

21.00 REF

21.00 REF

MATCH DRILL HOLES IN COVER  
TO ANGLE BRACKETS ON  
SUPPORT. INSTALL COVER USING  
MS27039-1-10 SCREW  
NAS1149F0316P WASHER  
6 PL (3 PL OPP)

AKC.500 ENSOLITE (A/R)  
UP1045.420 PACK CLOTH (A/R)  
8046 TRIM ADHESIVE (A/R)



R1.75 REF

CUTOUT ENSOLITE FOR INTERFACING WITH -15 & -17 ASSEMBLIES

② -23 LOWER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500

PREMIER AVIATION, INC.			
2000 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	IDENT NO.	REV.
D	OSUV8	B67-43001	61
SCALE	PT.	SHEET	10 of 45

ORIGINAL

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